

Work Order ID 154410

Monday, December 12, 2016 4:32:38 PM

154410

Page 1

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 1/9/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: 12/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4464	H

100 Weld per dwg A/R Aluminum rod Batch: 4131562 0.00

100

Large Fab

Large Fab

Memo

1- Weld D4023-3 cap as per dwg D4464

Achtung!
 Vor Einbau Sicherungstift herausnehmen
Attention,
 remove safety pin before installation
Atenção!
 Remova o pino de segurança antes de montar

DAS
43
9-89

FEB 12 2017

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1 Cpc

FEB 12 2017

112

0.00

112

Small Fab

Small Fab

Memo

0.19

1- Wet install baffles to front and back panel using rivet and Proseal as per dwg
 A/R Proseal Batch: 136665

1x

DAS
36
9-89
17/02/13

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114	QC5- Inspect part completeness to step on W/O	0.00							
114									
QC	Memo	0.00							
Quality Control									

DAS
30
9-89

FEB 14 2017

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
120									
Large Fab	Memo	0.40							
Large Fab	1- Weld D4001-1 and D4000-5 onto D4463-1 Top								
	2- Weld D3999-041/-043 doubler, ensure doubler and angle holes line-up for D4000-047								
	Transfer drill and c'sink D4975-1 bracket to bottom bracket, wet install as per dwg								
	Proseal 890B Batch: <u>136665</u>								
	3- Weld D4000-043 and D4000-045 on tank as per dwg.								
	4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 and wet install with rivets as per dwg. ***D4000-1 FLAT SURFACE MUST BE INSTALL UPWARDS AS PER DWG***								
	Proseal 890B Batch: <u>136665</u>								
	5- Install hinge wet with proseal as per dwg								
	A/R Proseal 890B Batch: <u>136665</u>								
	6-Weld D4463-7 fwd end								
	PURGE INSIDE OF TANK								
	7-Weld top D4463-1 using DT9811 and DT9810								

Handwritten notes and stamps:

- 4134410
- 1x
- PTO
- 17/2/21
- DAS 43 9-89 FEB 17 2017
- DAS 43 9-89 FEB 23 2017

DQA:

Date:

2017-04-05



QA Closed:

Date: MAR 09 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>154410</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4464-041</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>17-6321</u>		Scrap ☒		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☒	Composite ☐	Supplier ☐	
Date: <u>17-02-23</u>		Step #: <u>100</u>		QTY Effective: <u>1</u>		MRB (QS1042) Approval	
Description Work Order Deviation				Disposition			
D4023-3 GAS CAP. FORGOT TO TAKE IT OFF TANK WHEN WELDING TOUCH UP ON TANK. PLASTIC MELTED ON CAP.				SCRAP & DESTROY REPLACE D4023-3 → B132479			
				Completed By Cpl <u>17-2-23</u>			
				Lead hand / Supervisor Approval Verification DAS 38 9-89 FEB 23 2017			
				QC / QA Coordinator Approval DAS 38 9-89 FEB 23 2017			
Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	☒ Broken/Damage/Defect	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☒ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

PURGE INSIDE OF TANK

123	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

123

QC

Quality Control

Memo

Pressure Test as per dwg D4464

0.00

140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--

140

QC

Quality Control

Memo

0.00

DAS
38
9-88

FEB 22 2017

1 EL 17-2-22

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Item ID: D4464-041

Accept

N900040100Setup Start ***NS1***

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Start Date: 1/9/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/30/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
143	Outsource process - NDT per QSI038 4.1	0.00				1		FEB 24 2017	DAS 13 9-89
143									
Outsource2	Memo	30.00							
Outsource process - NDT	ISSUE P/O : 35386								
	LPI INSPECTION								
	C OF C IS REQUIRED								
145	Receive & Inspect for Damage & Mat'l Certs	0.00							
145									
Packaging	Memo	0.00							
Packaging									
147	QC5- Inspect part completeness to step on W/O	0.00							
147									
QC	Memo	0.00							
Quality Control									

IX 8217-02-24

DAS
38
9-89

FEB 27 2017

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Item ID: D4464-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fuel Tank Assembly

Start Date: 1/9/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							DAS 41 9-89
150									
HandFinish	Memo	0.20							17-2-25
Hand Finishing	1- Alodine on tank. No alodine inside								
160	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
160									
QC	Memo	0.00							FEB 27 2017
Quality Control									
164		0.00							
164									
Small Fab	Memo	0.25							
Small Fab	1- Brush Proseal 890A on all internal sheet metal folds Proseal 8990A Batch: <u>136665</u>								
	2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890B								
	A/R Proseal 890B Batch: <u>136665</u>								

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Start Date: 1/9/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
169	QC5- Inspect part completeness to step on W/O	0.00				1			
169									
QC	Memo	0.00							DAS 38 9.88 FEB 28 2017
Quality Control									
170		0.00				1			
170									
SprayPaint	Memo	0.18							17-02-28
Spray Painting	***MASK PROIOR PRIME AND PAINT AS PER DWG***								
	PRIME TEMPO GREY AS PER DWG AND QSI								
	PRIMER BATCH: <u>134518</u>								
	PAINT FLAT GREY AS PER DWG AND QSI								
	PAINT BATCH: <u>135260</u>								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC14- Inspect Spray Paint	0.00				1			DAS 38 MAR 04 2017
180 QC Quality Control	Memo	0.00							
190		0.00				1K			17/03/01 DAS 38 3-81
190 Small Fab Small Fab	Memo 1- Install placards, fuel sender, tank support, fuel filler splash guard assy, fuel cap as per dwg 2- Abrade surface with red scotch brite and install cushion using contact cement A/R Contact Cement Batch: 1300L 136812	0.25							
200	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 MAR 01 2017
200 QC Quality Control	Memo	0.00							

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MAR 02 2017

Picklist Print

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Page 1

Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG
REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG
REV.E DD VERF:JLM IPP REV:F 14.07.21 AS PER DWG REV.F DD
VERF:JLM IPP REV:G 15.01.15 AS PER DWG REV.G DD
VERF:JLM IPP REV:H 15.03.04 AS PER DWG REV.H9 DD
VERF:JLM IPP REV:I 15.06-17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-6

Purchased

No

Each

1,326.000

8

MS20470AD4-6

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

398

m133077

398

ST310

928

m134852

928

D3997-5

Manufactured

No

190

Each

8.0000

2

2

D3997-5

Placard

MAR 01 2017

Location

Loc Qty

Loc Code

ST069

8

143814

2

150868

6

9/15/2017

D3997-11

Manufactured

No

190

Each

10.0000

1

1

D3997-11

Placard

MAR 01 2017

Location

Loc Qty

Loc Code

ST069

10

127110

4

152610

6

11/8/2017

DAS
36
9-89

DAS
6
9-89

DAS
6
9-89

Picklist Print

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Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D3997-17

Manufactured No

190

Each

9.0000

1

1

D3997-17

Placard

MAR 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST069

9

129866

3

152258

6

11/8/2017

D3997-29

Manufactured No

190

Each

10.0000

1

1

D3997-29

Placard

MAR 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST069

10

127111

4

152611

6

11/8/2017

D3997-43

Manufactured No

190

Each

9.0000

1

1

D3997-43

Placard

MAR 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST069

9

127112

3

152179

6

11/8/2017

D3999-7

Manufactured No

120

Each

6.0000

1

1

D3999-7

Corner

B 155307 → 1x 43

FEB 16 2017

Location

Loc Qty

Loc Code

WA003

6

108621

3

146971

3

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Shop Packet Print

Page 2

Picklist Print

Page 3

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4000-1 Manufactured No

120 Each 10.0000 1 1

D4000-1

Fuel Supply Fitting

**

DAS
36
9-89

17/02/21

Location

Loc Qty

Loc Code

GA 10
137221 5
153006 5

10

5

5

D4000-5 Manufactured No

120 Each 5.0000 1 1

D4000-5

Fuel Tank Vent Fitting

**

DAS
43
9-89

FEB 16 201

B152339 → 1x

Location

Loc Qty

Loc Code

WA003 5
107388 5

5

5

D4000-9 Manufactured No

120 Each 15.0000 3 3

D4000-9

Grommet

**

DAS
36
9-89

17/02/21

Location

Loc Qty

Loc Code

GA 15
137219 15

15

15

D4000-045 Manufactured No

120 Each 0.0000 1 1

D4000-045

Fuel Pickup Fitting Assembly

**

DAS
36
9-89

17/02/21

B151966 (1x)

D4008-11 Manufactured No

120 Each 4.0000 1 1

D4008-11

Hinge Half

**

DAS
36
9-89

17/02/21

Location

Loc Qty

Loc Code

GA 4
129867 4

4

4

152992
(1x)

Picklist Print

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4008-041 Manufactured No

190 Each 6.0000 1 1

D4008-041

Fuel Filler Splash Guard Assembly

**

MAR 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST243

6

137305

6

D4023-3 Manufactured No

190 Each 9.0000 1 1

D4023-3

Cap And Flange

**

B129761 → 1x

DAS
43
9-89

FEB 12 2017

Location

Loc Qty

Loc Code

WA003

9

122537

1

129761

1

130907

1

132479

2

152210

2

152599

2

D4025-5 Manufactured No

190 Each 9.0000 1 1

D4025-5

Fuel Quantity Sender

**

MAR 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST240

9

129924

1

143838

4

147065

4

D4057-1 Manufactured No

120 Each 26.0000 3 3

D4057-1

Retaining Ring

**

17/02/14

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

26

107269

26

Picklist Print

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4062-041 Manufactured No

190 Each 8.0000 1 1

D4062-041

Tank Support Assembly

**

17/03/01 DAS 36 9-89

Location

Loc Qty

Loc Code

WA003

8

145585

8

D4125-1 Manufactured No

120 Each 5.0000 1 1

D4125-1

Fwd Sediment Bowl

**

B144614 → 1x DAS 43 9-89 FEB 12 2017

Location

Loc Qty

Loc Code

WA003

5

133944

1

144614

4

D4125-3 Manufactured No

120 Each 5.0000 1 1

D4125-3

Aft Sediment Bowl

**

B144763 → 1x DAS 43 9-89 FEB 12 2017

Location

Loc Qty

Loc Code

WA003

5

130324

1

144763

4

D4404-5 Manufactured No

120 Each 6.0000 2 2

D4404-5

Cushion, Fwd

**

MAR 01 2017 DAS 6 9-89

Location

Loc Qty

Loc Code

ST516

6

151103

4

153130

2

Picklist Print

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4462-1

Manufactured No

112

Each

5.0000

1

1

DAS

43

FEB 12 2017

9-89

****B150838→1x**

D4462-1

Baffle

Location

Loc Qty

Loc Code

WA003

5

145952

1

150838

4

D4462-3

Manufactured No

112

Each

4.0000

1

1

DAS

43

FEB 12 2017

9-89

****B150839→1x**

D4462-3

Baffle

Location

Loc Qty

Loc Code

WA003

4

146029

1

150839

3

D4463-041

Manufactured No

120

Each

2.0000

1

1

DAS

43

FEB 16 2017

9-89

****B152188→1x**

D4463-041

Tank Top Assembly

Location

Loc Qty

Loc Code

WA003

2

145568

2

D4463-3

Manufactured No

120

Each

4.0000

1

1

DAS

43

FEB 16 2017

9-89

****B146108→1x**

D4463-3

Tank Aft End

Location

Loc Qty

Loc Code

WA003

4

146108

4

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Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4463-5 Manufactured No

120

Each

13.0000

1 1

D4463-5

Tank Upper Cut Out

****B106751 → 1x43 DAS FEB 16 2017**
9-89

Location

Loc Qty

Loc Code

WA003

13

106751

11

121024

2

D4463-7 Manufactured No

120

Each

5.0000

1 1

D4463-7

Tank Fwd End

****B150840 → 1x43 DAS FEB 16 2017**
9-89

Location

Loc Qty

Loc Code

WA003

5

146961

1

150840

4

D4463-9 Manufactured No

112

Each

2.0000

1 1

D4463-9

Tank Back

****B150841 → 1x43 DAS FEB 12 2017**
9-89

Location

Loc Qty

Loc Code

WA003

2

148411

2

D4463-11 Manufactured No

112

Each

4.0000

1 1

D4463-11

Tank Front

****B154384 → 1x43 DAS FEB 12 2017**
9-89

Location

Loc Qty

Loc Code

WA003

4

146056

4

Picklist Print

Page 8

Monday, December 12, 2016 4:32:43 PM

Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4463-13

Manufactured No

190

Each

2.0000

1

1

✓ ***D4463-13***

Tank Bottom

****B146951 → 1x** **DAS 43** **FEB 12 2017**
9-89

Location

Loc Qty

Loc Code

WA003

1

146951

1

WA004

1

146049

1

D4577-041

Manufactured No

190

Each

5.0000

1

1

D4577-041

Fwd Access Panel Assembly

Location

Loc Qty

Loc Code

WA003

5

146803

5

D4577-1

Manufactured No

190

Each

8.0000

1

1

D4577-1

Rear Access Panel

Location

Loc Qty

Loc Code

WA003

8

146093

4

152343

4

D4577-3

Manufactured No

190

Each

7.0000

1

1

D4577-3

Middle Access Panel

Location

Loc Qty

Loc Code

WA003

7

146801

4

152207

3

17/02/27 **DAS 36**
9-89

B15644 (1x)

17/02/27 **DAS 36**
9-89

B156515 (1x)

17/02/27 **DAS 36**
9-89

156440 (1x)

Picklist Print

Monday, December 12, 2016 4:32:43 PM

Page 9

Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

D4968-1

Manufactured No

190

Each

6.0000

1

1

D4968-1

Side Cushion

MAR 01 2017

Location

Loc Qty

Loc Code

ST400

6

151546

6

Each

5.0000

1

D4975-1

Manufactured No

D4975-1

Bracket

Location

Loc Qty

Loc Code

WA003

5

145518

5

Each

483.0000

24

AN3-5A

Purchased No

AN3-5A

Bolt

Location

Loc Qty

Loc Code

FP001

155

m134502

155

over003

300

m136182

300

ST350

28

m135058

28

Each

27.0000

5

AN3H5A

Purchased No

AN3H5A

Bolt

Location

Loc Qty

Loc Code

ST349

2

m132680

2

ST350

25

m134852

25

MAR 01 2017

Picklist Print

Monday, December 12, 2016 4:32:43 PM

Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-7A Purchased No

Each 184.0000 4

AN3-7A

Bolt

**

MAR 01 2017

DAS 6 9-89

Location

Loc Qty

Loc Code

ST349

184

m135058

184

Each

3,598.000

4

**

17/02/21 DAS 36 9-89

MS20426AD4-4

Purchased No

MS20426AD4-4

Rivet

Location

Loc Qty

Loc Code

GA

1641

125445

1641

ST312

1957

m132536

1957

Each

4,567.070

165

**

17/02/13 DAS 36 9-89

MS20470AD4-4

Purchased No

MS20470AD4-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

CCK004

0.001

M135133

0.001

GA

2118.069

M134294

101

M134848

378

M135133

0.069

M135536

67

M136042

1572

over004

2069

M136301

2069

ST310

380

M132803

380

165

Picklist Print

Page 11

Monday, December 12, 2016 4:32:43 PM

Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

190

Each

1,653.000

4

4

MAR 01 2017

MS21042L3

Nut

**

DAS
6
9-89

6873
SUG

Location

Loc Qty

Loc Code

CCK007

600

M136192

600

FP001

100

m135945

100

GA

176

m134360

108

m135135

68

ST303

777

m135945

177

M136044

600

136838

DAS
36
9-89

NAS1149D0332J

Purchased

No

190

Each

1,651.000

13

13 12

NAS1149D0332J

Washer

**

Location

Loc Qty

Loc Code

FP001

100

m134848

100

GA

146

m134848

146

ST260a

1200

m136015

1200

ST264

205

m135672

205

12

DAS
36
9-89
NAS 1149 D0316J

M 134502

Qty (1x)

DAS
6
9-89

MAR 01 2017

Picklist Print

Page 12

Monday, December 12, 2016 4:32:43 PM

Work Order ID: 154410

154410

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/9/2017

Required Date: 1/30/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

1,535.000

24

24

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

332

m134055

332

ST260a

1000

m136318

1000

ST263

203

m135864

203

MAR 01 2017
DAS
9:56 AM

136787

ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-3	FUEL CAP AND FLANGE
14	1	D4025-5	FUEL SENDER
15	3	D4057-1	RETAINER
16	1	D4062-041	TANK SUPPORT
17	1	D4125-1	FWD SEDIMENT BOWL
18	1	D4125-3	AFT SEDIMENT BOWL
19	2	D4404-5	CUSHION, FWD
20	1	D4462-1	BAFFLE
21	1	D4462-3	BAFFLE
22	1	D4463-041	TOP TANK ASSEMBLY
23	1	D4463-3	TANK AFT END
24	1	D4463-5	TANK UPPER CUT OUT
25	1	D4463-7	TANK FORWARD END
26	1	D4463-9	TANK BACK
27	1	D4463-11	TANK FRONT
28	1	D4463-13	TANK BOTTOM
29	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
30	1	D4577-1	REAR ACCESS PANEL
31	1	D4577-3	MIDDLE ACCESS PANEL
32	1	D4988-1	CUSHION, SIDE
33	1	D4975-1	ANGLE BRACKET
34	24	AN3-5A	BOLT
35	5	AN3H5A	BOLT
36	4	AN3-7A	BOLT
37	4	MS20426AD4-4	RIVET, CSK
38	165	MS20470AD4-4	RIVET, PANHEAD
39	8	MS20470AD4-6	RIVET, PANHEAD
40	4	MS21042L3	NUT
41	13	NAS1149D0332J	WASHER
42	24	NAS1149D0363J	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154410

RELEASED
2015-06-18
ECN 15-583

H	REPLACED NOTE 8 (SHT 2), ADDED NOTE 14 (SHT 2), ADDED AUXILIARY VIEW (SHT 3), ADDED NOTE 15 (SHT 4), REPLACED NOTE 13 (SHT 5), SHT 4 WAS SHT 3, SHT 5 WAS SHT 4, REMOVED D4124-1 TABS & AN3-6A BOLTS, CHEMICAL CONVERSION COAT NOW AFTER WELDING (SHT 5), ADD AN3-7A BOLTS	CC	15.02.06
G	FINISH "FLAT GREY" WAS "GREY" (SHT 2); PICTORIAL UPDATE FOR D4000-1 & D4462-1	AP	14.12.05
F	AN3-5A WAS AN3-4A QTY. 24 (ZN D6-2) AN3-5A WAS AN3-5A QTY. 5 (ZN D7-2) MS20470AD4-6 WAS MS20426AD4-6 QTY. 8 (ZN B5-2) D4000-1 IS NO LONGER INSTALLED WITH COUNTERSUNK RIVETS UPDATE NOTE 10 ON SHEET 3	ML	14.08.27
E	UPDATED -041 WITH RE-DESIGNED D4463-3/9/-11 AND D4462-1/-3. D4988-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35206-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B8-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4464 SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	CC		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS	TANK ASSEMBLY	
DATE	15.02.06		

APPROVED

DQA: _____ Date: _____



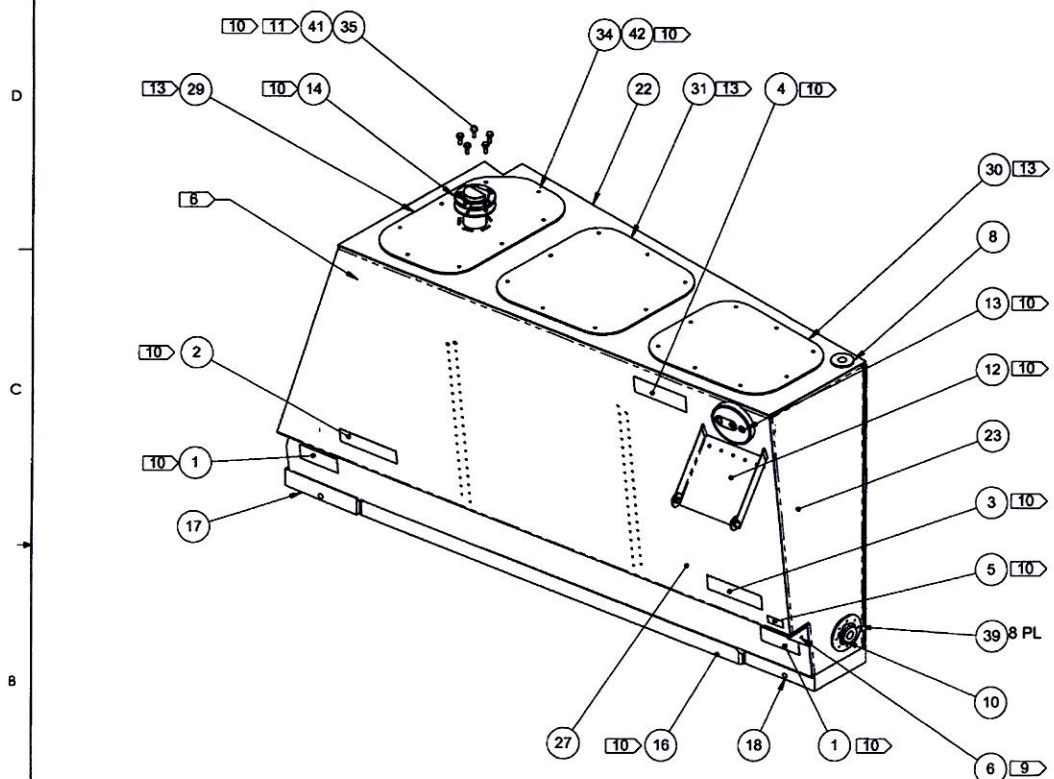
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

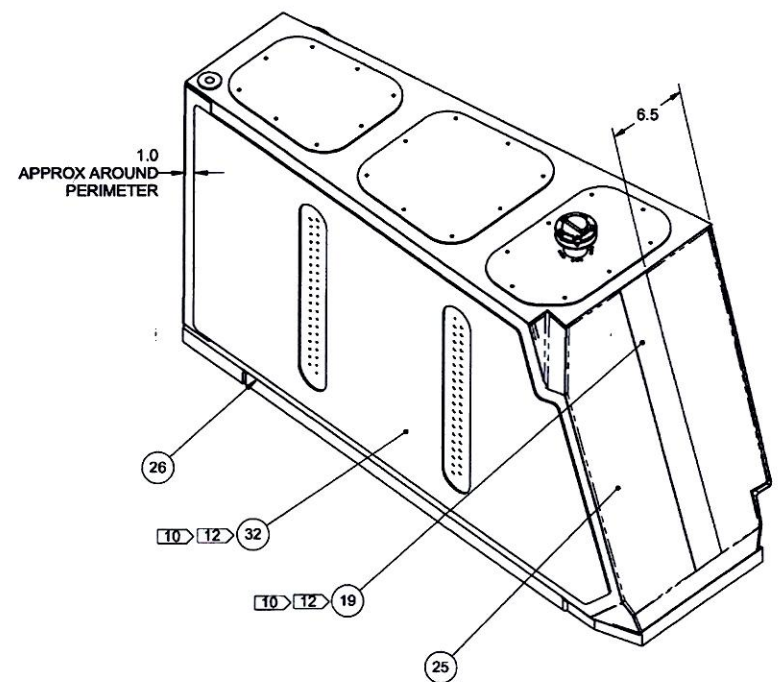
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

8 7 6 5 4 3 2 1



D4464-041 FUEL TANK ASSEMBLY



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 39.52 lbs
- 8) LPI AND PRESSURE TEST PER DART QSI 038 6.3
- 9) MASK PRIOR TO FINISH
- 10) INSTALL AFTER FINISH
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-1/-3 ACCESS PANELS WET WITH PROSEAL P/S 890B.

RELEASED
11 2015-06-18

APPROVED	DESIGN	ML	DART AEROSPACE LTD	
	DRAWN	CC	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. H
	MFG. APPR.	DD	D4464	SHEET 2 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	TANK ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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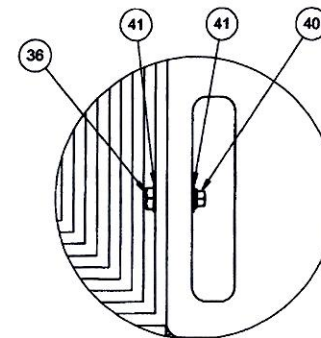
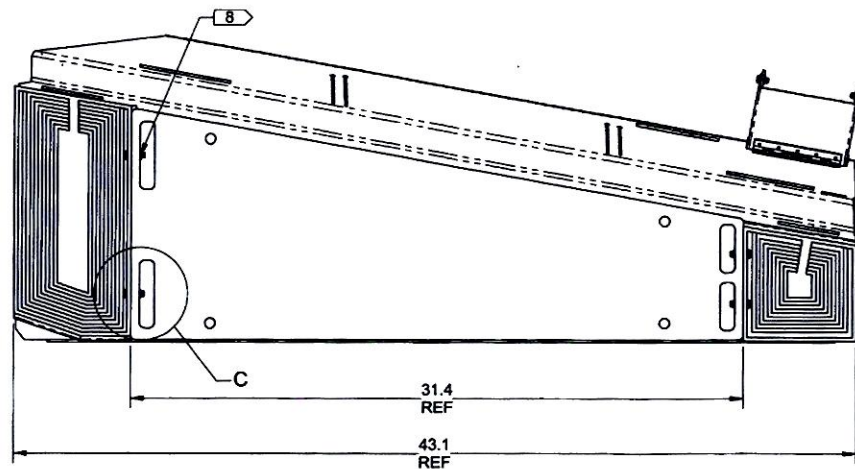


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					



DETAIL C
SCALE 3X

D4464-041 FUEL TANK ASSEMBLY
AUXILIARY VIEW

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) TRANSFER DRILL HOLES FROM D4125-1/-3 SEDIMENT BOWLS TO D4062-041 TANK SUPPORT ASSEMBLY

RELEASED
2015-06-18
on

APPROVED	DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	CC		
	CHECKED	AP	DRAWING NO.	REV. H
	MFG. APPR.	DD	D4464	SHEET 3 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	TANK ASSEMBLY	NTS
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DQA: _____ Date: _____

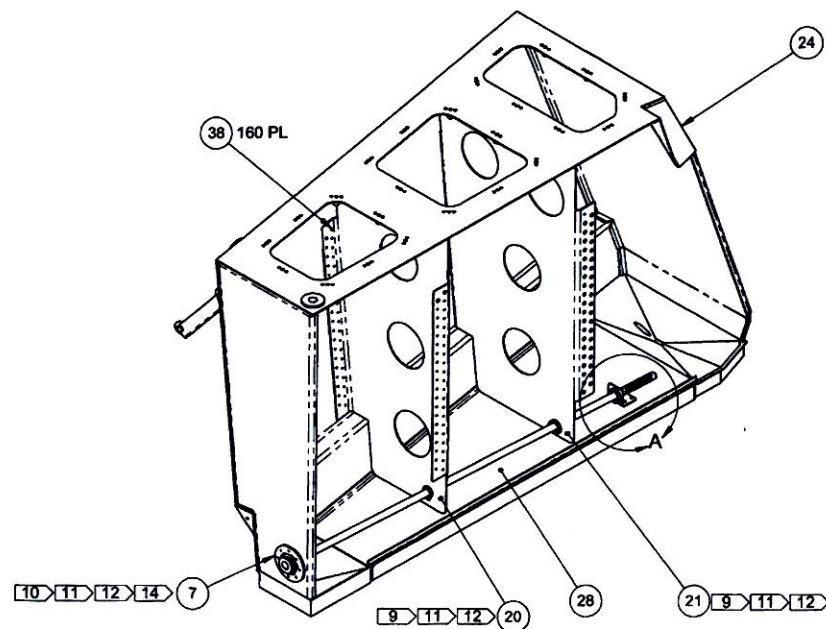


WORK ORDER NON-CONFORMANCE / UPDATE

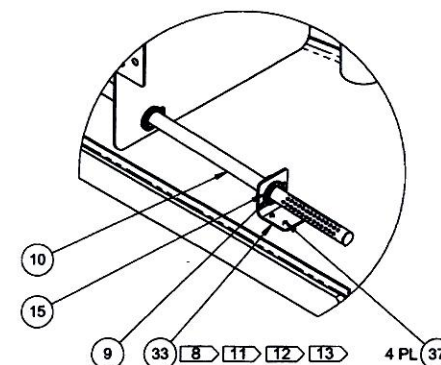
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____					



D4464-041 FUEL TANK ASSEMBLY 
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\varnothing 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\varnothing 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK
- 14) INSTALL D4000-1 FITTING WITH FLAT FACING UPWARDS
- 15) BRUSH PROSEAL 890A ON ALL INTERNAL SHEET METAL FOLDS

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DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CC		
CHECKED	AP	DRAWING NO.	REV. H
MFG. APPR.	DD	D4464	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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R 2015-06-16

DQA: _____ Date: _____

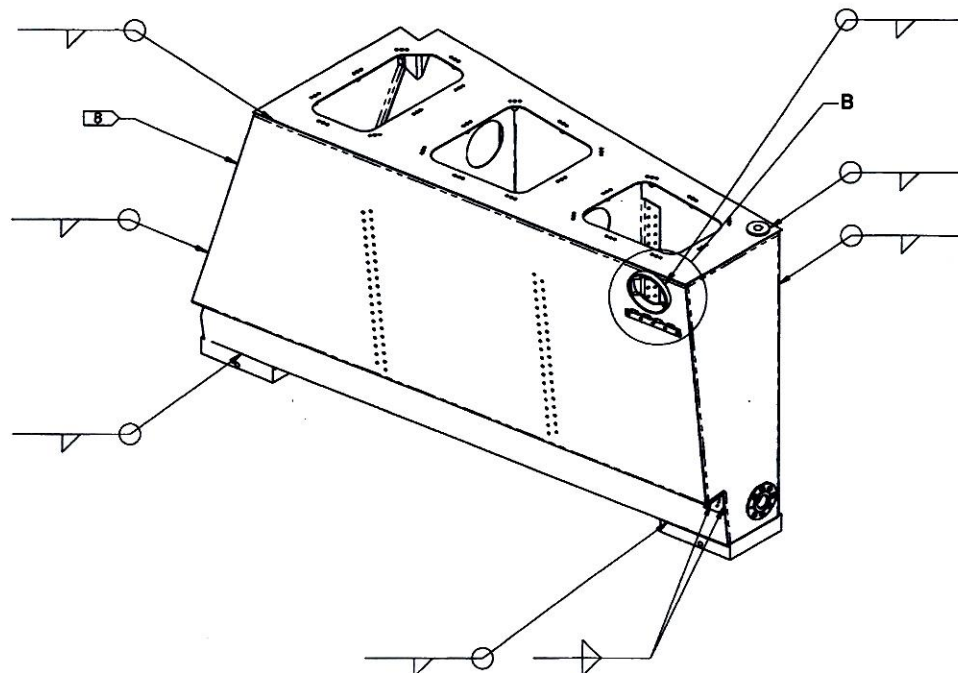


WORK ORDER NON-CONFORMANCE / UPDATE

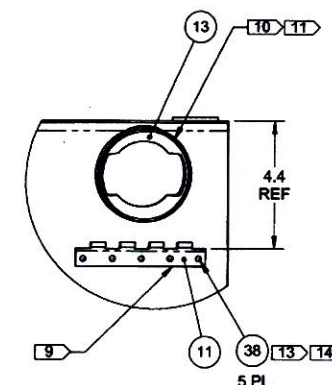
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					



D4464-041 FUEL TANK ASSEMBLY
WELDING AND RIVETING DETAIL



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 14) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

RELEASED
2015-06-16

APPROVED	DESIGN	ML	DART AEROSPACE LTD	
	DRAWN	CC	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. H
	MFG. APPR.	DD	D4464	SHEET 5 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	TANK ASSEMBLY	NTS
DATE		15.02.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35386**

Purchase Order Date 2/22/2017

PO Print Date 2/24/2017

Page Number 3 of 3

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-678-5636

Ship To Contact

Ship To Phone

Ship Via: Delivered

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total: \$167.50

6 154410

D4464-041 AUX TANK

2/28/2017

Yes

2/28/2017

1.00

\$450.00

\$450.00

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$450.00

PO Total: \$1,120.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 2/24/2017

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO31234	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference:
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 1 FUEL TANK ASSY AND 4 CROSSTUBES AS PER PO

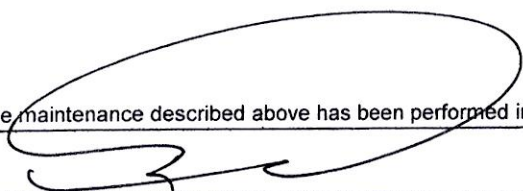
1 FUEL TANK ASSY, ITEM ID# D4464-041, WORK ORDER ID# 154410

SP17-02

4 FWD CROSSTUBES, ITEM ID# D212-664-101, WORK ORDERS ID# 157116, 157117, 157118, 157119

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 NO CRACK FOUND PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, EMU. MPO15896, DEV. MPO11715, UV LIGHT M-20142						FEB 23 2017	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: FEB 23 2017
Name: RAFIK MELIKIAN		